

Date: Thursday, 06/11/2008 9:53:52 AM  
 User: Julie Dawson

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D407-667-205  
 Job Number : 43213  
 Estimate Number : 10804  
 P.O. Number :  
 This Issue : 06/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D407667205  
 First Issue : / / Type : CROSSTUBES Drawing Number : R08-097  
 Previous Run : 00015 Drawing Revision :  
 Material :  
 Due Date : 12/11/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JUD 08.11.06  
 Comment :

## Additional Product

<b>DART</b> Dart Aerospace Ltd. 270 ABERDEEN ST. HAWKESBURY ON, CANADA K0A 1K0		TE APPROVAL # 1989 TEL: 1-818-332-5200	
P/N	D407-667-205	CHG	CHG004
DESC.	Crosstube Aft High	STC	SH01-5
LOT	B39364	STC	SR01304NY
MODEL	Bell 407	STC	

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D407667205

Crosstube Aft



Comment: Qty.: 1.0000 Each(s)/Unit. Total : 1.0000 Each(s)  
 Crosstube Aft  
 Original B39364 @ CHG004

2.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1 :

-Disassemble the tube completely,, and discard all the hardware, except for the center support. RT 08-11-10

-Strip and remove all the paint, on the tube, and the center support.

-Re-polish the tube, with an EXTRA FINE GRIND ONLY to remove any left over paint, or primer. RT 08-11-12

3.0

CHEMICAL TREAT

CHEMICAL TREATMENT



Comment: CHEMICAL TREATMENT

Chemical conversion coat as per QSI 005

\*\*\* DO NOT DO THE CUFF'S IN THE TANK DUE TO THE NUT PLATES AND RIVETS\*\*\* RT 08-11-12

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

\*\*\* ENSURE THE CUFFS WERE NOT DUNKED IN THE TANKS\*\*\*

Cuffs were not dunked

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 06/11/2008 9:53:52 AM  
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## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 43213

Part Number: D407667205

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ET 08-11-17

6.0	QC14	INSPECT SPRAY PAINT
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Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

M

08 11 18

(1)

7.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.3524 f(s)/Unit Total : 1.3524 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

37667

ET 08-11-18

8.0	D2873043	Nut Plate Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

NIA

9.0	D2873045	Nut Plate Assembly
-----	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate

NIA

10.0	D28941	2.750 Support
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2894-1 Support

NA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 06/11/2008 9:53:52 AM  
User: Julie Dawson

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 43213

Part Number: D407667205

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D31901	Chafing Shield
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3190-1 Chafing Shield 37969

RT 06-11-18

12.0	D3595	Rubber Cushion (per sq ft)
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Comment: Qty.: 0.0246 sf(s)/Unit Total: 0.0246 sf(s)

Rubber Cushion

2X .750" X 4.30"

Batch:

D3595-063-450 B 41108 RT 06-11-18

13.0	MS20601AD4W8	RIVET
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Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

NIA

14.0	MS2192022	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp 107356

RT 06-11-18

15.0	MS2192025	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 109644

RT 06-11-18

16.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8674. Install chafing shield as per Dwg D407-667-245. Note:  
(3) top holes should be facing up.

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

RT 06-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 06/11/2008 9:53:52 AM  
User: Julie Dawson

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 43213

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Install support with magnobond and install clamps as per Dwg D407-667-245 using installaiton jig DT9025.

Torque clamps to 80-100 in lb

A/R Magnobond Batch: 106966

EXP: 09-04-01

RT  
08-11-18

4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/19

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RTD

\*\*\* Record the batch #'s for the D407-667-205 B41195 kit that was returned from the N/C replacement onto this W/O, and identify with the new batch number\*\*\*

New labels and paperwork is required with the new batch # @ CHG006 per ECN1225 JO 08.11.06

19.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M109061

SP

20.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M108827

SP

21.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt


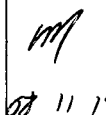
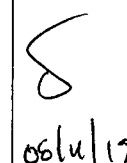

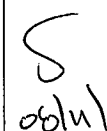

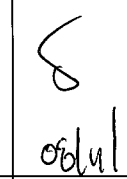
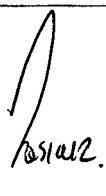
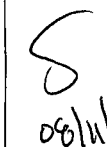
M109282

8/11/19

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D407-667-205 PAR #: N/A Fault Category: Prod / x-tube NCR: (Yes) No DQA: D Date: 08/12/16  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: AD Date: 08/12/16

NCR: 43213		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/11/19	18.0	x-tube was hit by some 350 steps Duffin moving buggys to be packaged LC employee thought the		touch up bottom of cuff were it was marked by steps with Iron as per ASFOSS.	 08/11/19	 08/11/19	 08/11/19	 08/11/19
		Duggy <del>was</del> would clear but it chort. Human error		(markings are not to the) prince		 08/11/19	 08/11/19	 08/11/19

NOTE: Date & initial all entries



Date: Thursday, 06/11/2008 9:53:52 AM  
User: Julie Dawson

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 43213

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M109068

SP

23.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M109282

8/11/19

SP

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Ensure qty's and batch #'s match the original W/O (B39363, re-worked on W/O41195)

See 12.03

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and in kanban rack

Location: 53

REV E

8/12/13

SP

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16

Job Completion



U 08.12.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 13/08/2008 9:51:09 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D407-667-205  
 Job Number : 41195  
 Estimate Number : 10804  
 P.O. Number :  
 This Issue : 13/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D407667205  
 First Issue : // Type : CROSSTUBES Drawing Number : ECN1225 - REWORK  
 Previous Run : 41182 Drawing Revision :  
 Material :  
 Due Date : 22/08/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment :

Additional Product

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D407-667-205	CHG	CHG004
DESC.	Crosstube Aft High	STC	SH01-5
LOT	B39363	STC	SR01304NY
MODEL	Bell 407	STC	
MADE IN CANADA		D2729-1	

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

PULL FROM STOCK:

1 X D407-667-205 B39363 CHG004 ml 08 08 26

REFERENCE ONLY

①

2.0 D407667205 Crosstube Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Crosstube Aft ml 08 08 26 ①

3.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1  
 REWORK TUBE PER ECN1225  
 MOVE BOTH CHAFING SHIELDS 0.375"  
 TOWARD BL 0.0. ml 08 08 27 ①

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT FOR ORIGINAL KIT  
 TO BE INCLUDED S 08/08/27 ①

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 39363

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 107973

ml 08 05 27

24.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8674. Install chafing shield as per Dwg D407-667-245. Note: ml 08 05 28 ①  
(3) top holes should be facing up.

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe ml 08 05 27 ①

3-Install support with magnobond and install clamps as per Dwg D407-667-245. Torque clamps to 80-100 in lb ml 08 05 28 ①

A/R Magnobond

Batch: 107621

EXP: 08/2009

Time: 10:30 am

ml 08 05 27 ①

4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint. ml 08 05 28 ①

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 08 05 28 ①

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

REFERENCE ONLY

27.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M10793

AS 08/05/29 ①

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 39363

Part Number: D407667205

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	MS21042L5	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M107464

AS 08/05/29 (X)

29.0	AN510A	Bolt
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M107013

AS 08/05/29 (X)

30.0	AN532A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M106519

REFERENCE ONLY  
AS 08/05/29 (X)

31.0	AN960JD516	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M107534

AS 08/05/29 (X)

32.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/05/29 (X)

33.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and in kanban rack

Location:

~~D-1~~

8/5/29

S/D

34.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/05/29

Job Completion



mf 08-05-29

## Process Sheet

Number: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Number: 39364

Part Number: D407667205

Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 107973

ml 080527

REFERENCE ONLY

24.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8674. Install chafing shield as per Dwg D407-667-245. Note:

(3) top holes should be facing up.

ml 080528 (1)

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

ml 080527 (1)

3-Install support with magnobond and install clamps as per Dwg D407-667-245. Torque clamps to 80-100 in

lb

A/R Magnobond

Batch: 107621

EXP: 08/2009

Time: 9:30am

ml 080527

ml 080528 (1)

4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

ml 080528 (1)

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 080528 (1)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M107013

ml 080529 (1)

## Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Number: 39364

Part Number: D407667205

Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M107464

29.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-10A

Description Batch

Bolt

M107013

30.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

4 AN5-32A

Description Batch

Bolt

M106519

31.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

18 AN960JD516

Description Batch

Washer

M107534

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and in kanban rack

Location: 0

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

08-05-29

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 27.7 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND  
6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO  
PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE  
SUPPORT.  
**NOTE:** MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS.  
ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF  
CROSSTUBE, PER QSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE  
OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

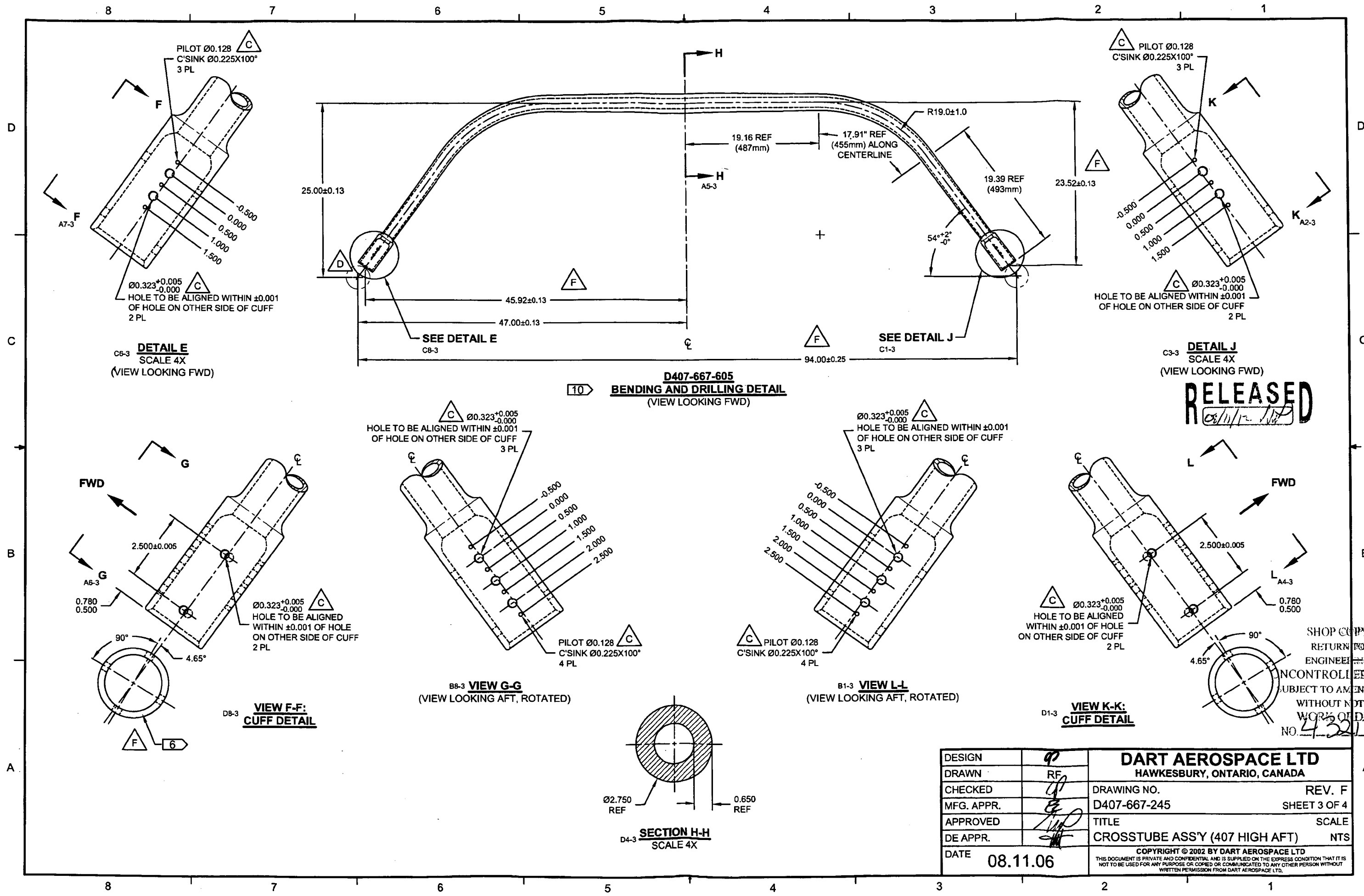
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F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. F
MFG. APPR.	97	D407-667-245	SHEET 1 OF 4
APPROVED	97	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

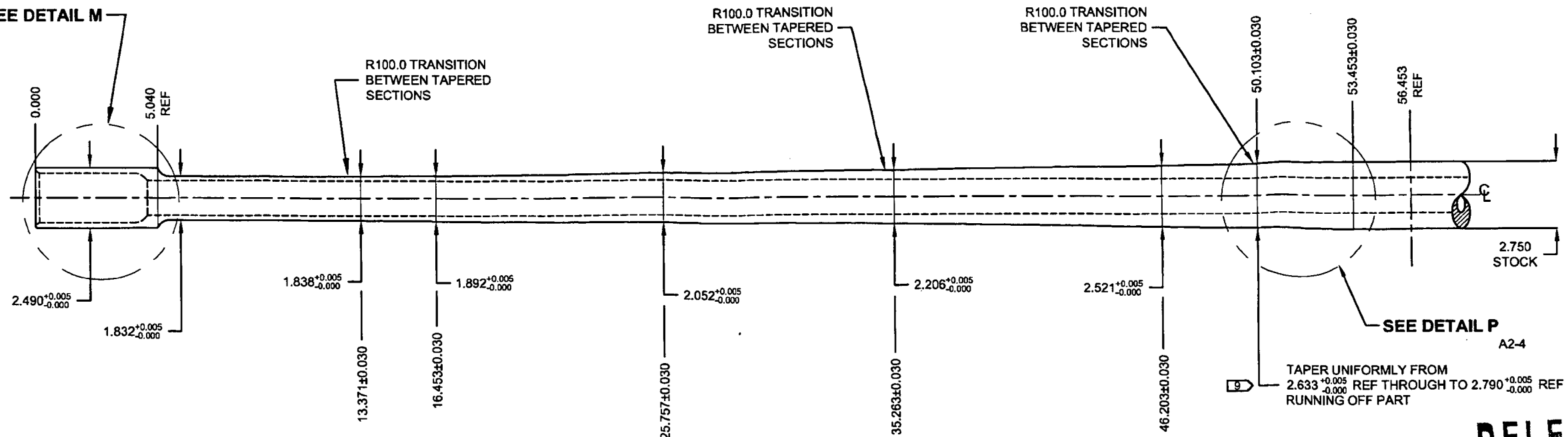






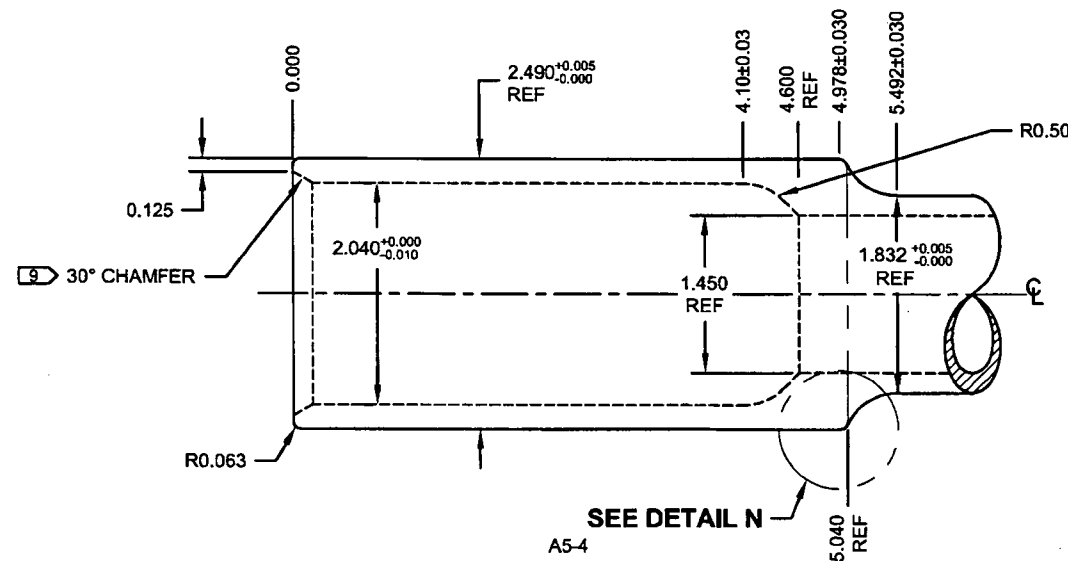
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SEE DETAIL M  
A7-4

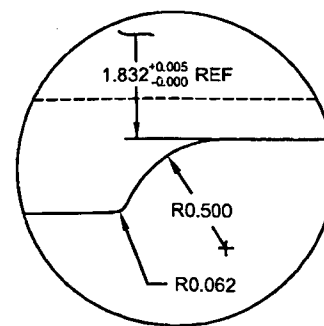


D407-667-245 MACHINING DETAIL

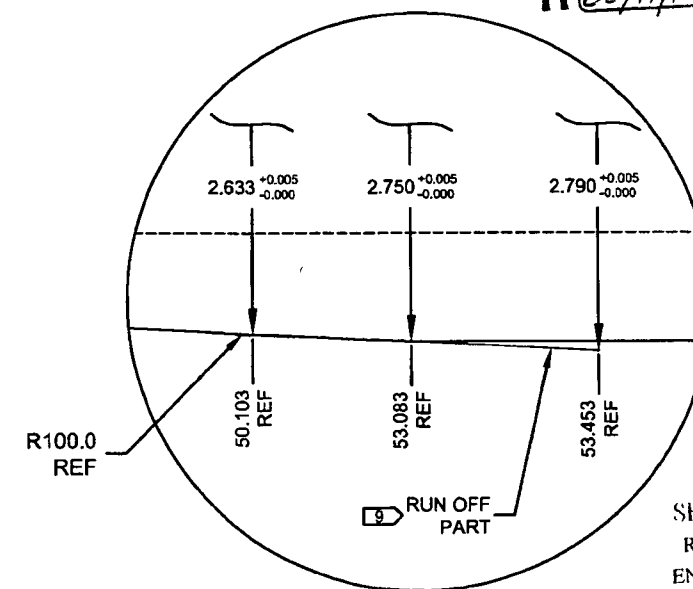
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08/11/12



D8-4 DETAIL M: CROSSTUBE CUFF  
SCALE 3X



B6-4 DETAIL N: CUFF TRANSITION  
SCALE 2X



C1-4 DETAIL P: TAPER RUN-OFF  
NOT TO SCALE

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CHECKED	90	DRAWING NO.	REV. F
MFG. APPR.	90	D407-667-245	SHEET 4 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
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